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D350-591-121
Job Sheet 184887



Part No: D350-591-121

Job Qty: 3 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG IIN-D350-591 REV H, D2351-041 REV E IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF IPP rev. F 06.02.23 added grinding EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Large Fab-4		SL4
110	Large Fab	3 pcs	11/9/18	11/9/18	0.00	2.04	Large Fab 8		SL4
120	CNC Bend Skid tubes	3 pcs	11/9/18	11/9/18	0.38	0.88	CNC Bend Skid tube		DAS 38
122	QC	3 pcs	11/9/18	11/9/18	0.00	0.00	QC5		9-89
140	Large Fab	3 pcs	11/9/18	11/9/18	0.00	2.04	Large Fab 2		SL4
150	QC	3 pcs	11/9/18	11/9/18	0.00	0.00	QC9		SL4
160	QC	3 pcs	11/9/18	11/9/18	0.00	0.00	QC5		SL4
170	HandFinish	3 pcs	11/9/18	11/9/18	0.00	0.56	HandFinish1		D.R 18/12/03
180	QC	3 pcs	11/9/18	11/9/18	0.00	0.00	QC7-2		SL4
190	Large Fab	3 pcs	11/9/18	11/9/18	0.00	2.04	Large Fab 2		CC
220	QC	3 pcs	11/9/18	11/9/18	0.00	0.00	QC10		SL4
230	QC	3 pcs	11/9/18	11/9/18	0.00	0.00	QC5		SL4
240	HandFinish	3 pcs	11/9/18	11/9/18	0.00	0.56	HandFinish1		BL 18-12-6
250	Powdercoat	3 pcs	11/9/18	11/9/18	0.00	0.49	Powdercoat1		DEC 18-12-02
260	HandFinish	3 pcs	11/9/18	11/9/18	0.00	0.56	HandFinish3		DEC 17 2018
270	QC	3 pcs	11/9/18	11/9/18	0.00	0.00	QC3		68
280	Packaging	3 pcs	11/9/18	11/9/18	0.00	0.00	Packaging1-3		68
290	QC	3 pcs	11/9/18	11/9/18	0.00	0.00	QC4		68
300	Packaging	3 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		68
305	DC	3 pcs	11/9/18	11/9/18	0.00	0.00	DC		68
310	QC21-FG	3 Ea	11/9/18	11/9/18	0.00	0.00	QC21		68

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 2- Drill holes as per dwg using DT8230.

Descriptions: 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041. Use DT8033 jig to make sure bend is good and fits the jig.

140 - 1-Bevel Fwd and Aft end for welding 2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033 A/RAluminum Rod M1347853-Do not Grind Flush

190 - 1-Rivet Leg Assembly as per Dwg D2351 2-Weld Fwd End Plate per QSI 004 & Dwg D2351 A/RAluminum Rod _____ 3-Grind end plate flush.

250 - START TIME: 2:25 OVEN TEMPERATURE: 300° FINISH TIME: 2:55.

300 - Identify and pack for shipping as per PPP D350-591-121 Location:FG039

305 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

Wing walk M138963.

Job BOM

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	1.5000 Ea (.5 ea)	90-Start up Operation	B164533-775
D2850-1	End Bracket	3 Ea (1 ea)	140-Large Fab	5133680 5133680
D2582 ✓	Hi-Skid Step Leg Assembly	3 Ea (1 ea) ✓	190-Large Fab	5121733
D2673-34 ✓	End Plate ✓	3 Ea (1 ea) ✓	190-Large Fab	5077409
MS20600-AD4W3 ✓	Cherry Rivet	48 Ea (16 ea) ✓	190-Large Fab	5110003
AN3-37A	Bolt	6 Ea (2 ea)	280-Packaging	50060130 510041214
AN4-13A	Bolt	3 Ea (1 ea)	280-Packaging	5115326
AN4-16A	Bolt	6 Ea (2 ea)	280-Packaging	5134683
D2230-1	Mounting Lug	3 Ea (1 ea)	280-Packaging	5125816
D2230-3	Mounting Lug	3 Ea (1 ea)	280-Packaging	5131811
D2732-030	Rubber Cushion - 3"	6 Ea (2 ea)	280-Packaging	5127212
MS21042L3	Nut	6 Ea (2 ea)	280-Packaging	5132364
MS21042L4	Nut	9 Ea (3 ea)	280-Packaging	5112434
NAS1149D0363J	Washer	12 Ea (4 ea)	280-Packaging	5107782
NAS1149D0463J	Washer	18 Ea (6 ea)	280-Packaging	5002780

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	26	0
140-Large Fab	D2850-1	3	0	0
190-Large Fab	D2582	3	0	0
	D2673-34	3	39	0
	MS20600-AD4W3	48	335	0
280-Packaging	AN3-37A	6	76	0
	AN4-13A	3	1,312	0
	AN4-16A	6	461	0
	D2230-1	3	41	0
	D2230-3	3	242	0
	D2732-030	6	272	0
	MS21042L3	6	2,639	0
	MS21042L4	9	4,133	0
	NAS1149D0363J	12	1,793	0
	NAS1149D0463J	18	4,955	0

Part Specifications

Specifications could not be found.

Plex 10/17/18 1:14 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Container No: S125051 Part: D350-591-121 Job No: 184887 Serial No/Batch: S125051 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH92-6 Issue 1 FAA STC SH967NE 04/12/21, BRAZIL 1		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Parts ☐ Assembly/Damage/Damage ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Counter Sink ☐ Cut Too Short ☐ Instructions Incomplete/Incorrect ☐ Drill Hole ☐ Power Loss/Single ☐ Fallin/Program ☐ Chain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misaligned ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			

Change Record

PAGE 1 OF 1

Part Number: D350-591-121

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

[illegible]

Change Record

PAGE 1 OF 1

Part Number: D350-591-121

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH

[illegible]

